

Date: Wednesday, 2/20/2008 4:22:31 PM
User: Kim Johnston


Process Sheet



10

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X16")
Job Number : 37535	
Estimate Number : 12664	
P.O. Number	Part Number : D206559011
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2435 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 34288	Material :
Written By :	Due Date : 3/3/2008 Qty: 6 Um: Each
Checked & Approved By : <u>KS 080221</u>	
Comment : Est Rev:C 04.02.17 Blank size changed KJ/JLM	
Est Rev:D 07-01-02 Was K10007 JLM	



OK TO MANUFACTURE
STOCK
KS 08-02-21

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		 KS 08-02-27
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPPD206-559-011. CHG005		



08/02/07

2.0	MUHMWB10	UHMW 1" Black
		
Comment: Qty.: 4.5491 sf(s)/Unit Total : 27.2948 sf(s) blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) 1105862 Batch: 1105862 9mk 08/02/27		

6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2435 Identify as D2435 3-Deburr		

H.A./J.L 08/03/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

H.A./J.L 08/03/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:22:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 37535

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 08/03/09 (12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total: 9.9960 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion 35769

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block 33604

2 D2435(ref only) Bearpaw 37535

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp 36027

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer 37210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 37535

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M106375

Handwritten signature

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: M105653

Handwritten signature

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M106277

Handwritten signature

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105938

Handwritten signature

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M107035

1 Paperwork package

Handwritten signature

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten signature
08/03/07 *Handwritten signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:22:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 37535

Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location:

Rev A

50

AS-08/03/07 (x6)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08/03/07 (6)

Job Completion



mi 2008/03/07 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

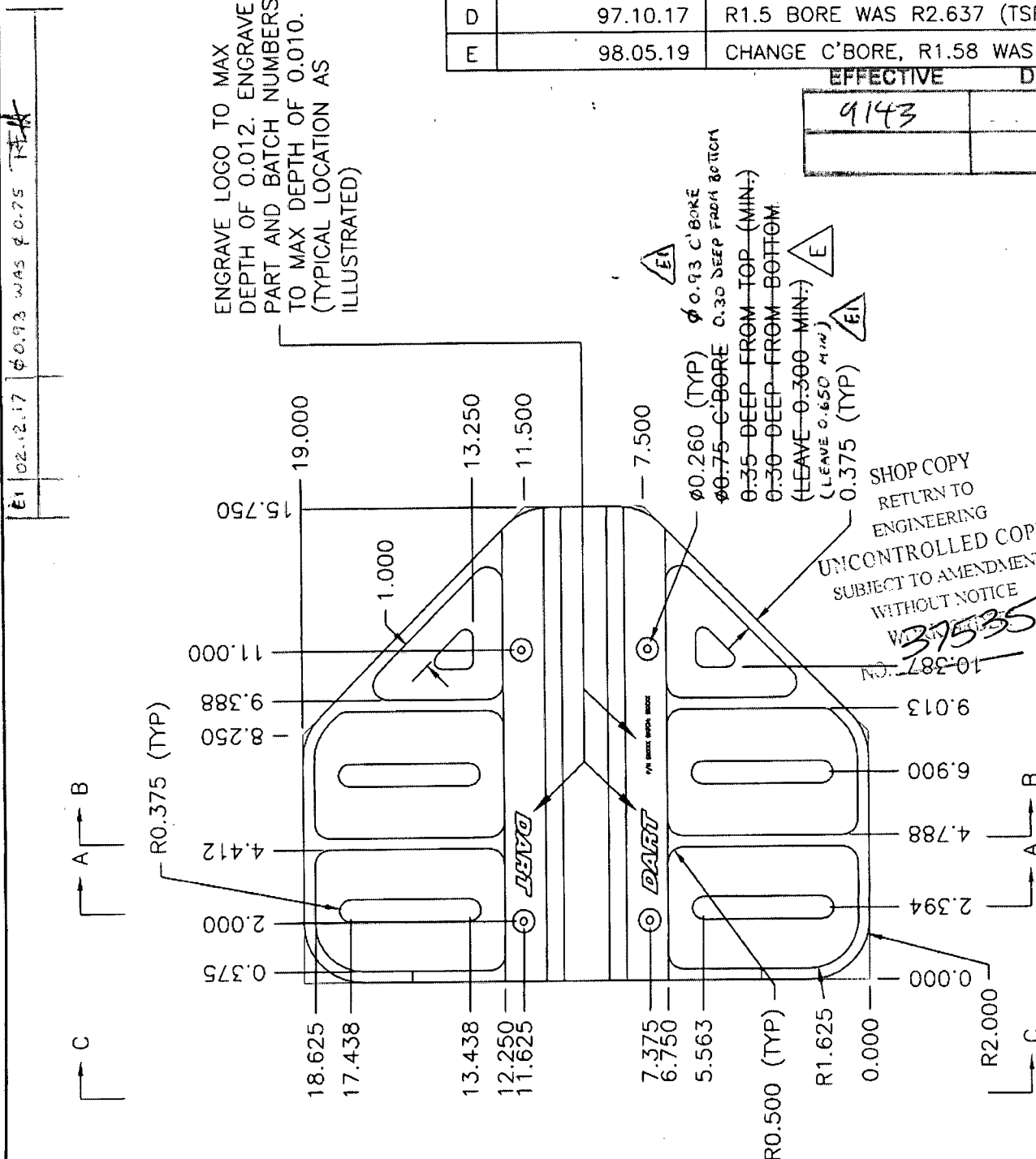
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>Q</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOs

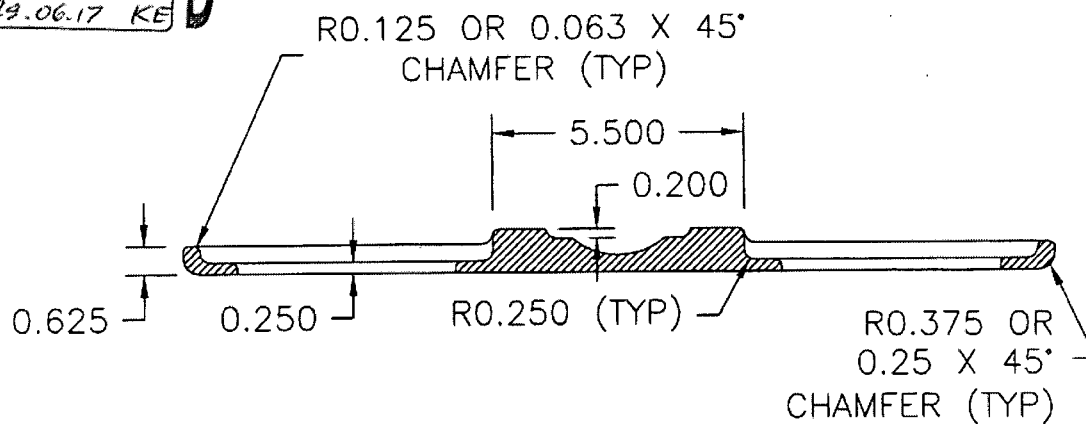
9143	

RELEASED
48.06-17 KEENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

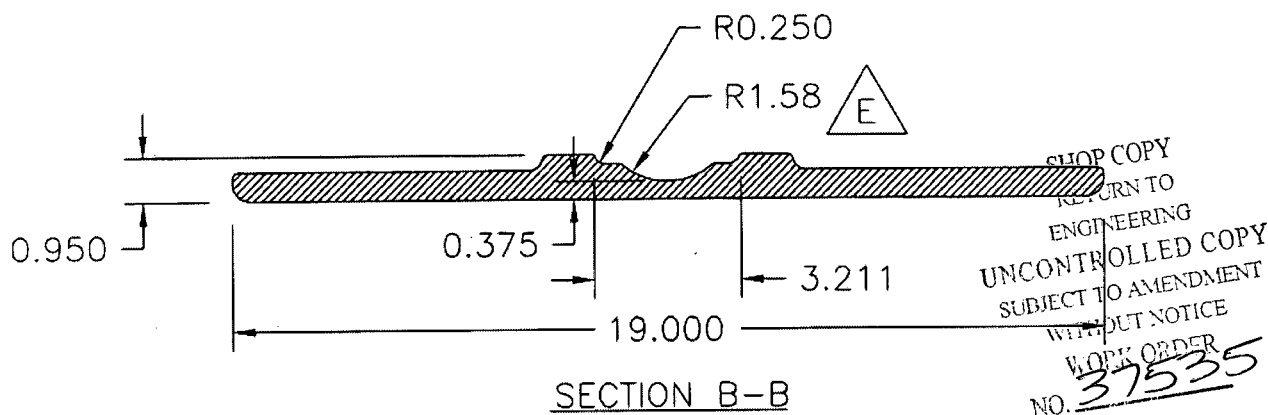


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

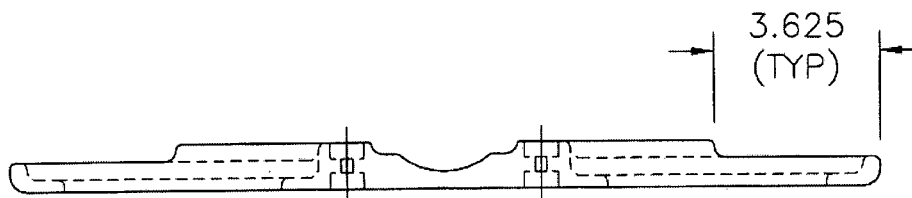
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

DART AEROSPACE LTD		Work Order:	37535
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.05 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.194	✓			
D	R0.250	+/-0.030	r.250	✓			
E	0.250	+/-0.010	.255	✓			
F	0.625	+/-0.030	.630	✓			
G	0.25 x 45°	+/-0.030	.246 x 45°	✓			
H	0.375	+/-0.010	.378	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.951	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.930	✓			
M	0.30	+0.030/-0.000	.308	✓			
N	0.375	+/-0.030	.375	✓			
O	7.375	+/-0.030	7.374	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.015	✓			
R	9.000	+/-0.010	9.001	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by:	J.L	Audited by:	S.F	Prototype Approval:	N/A
Date:	08/03/04	Date:	08/03/04	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

Date: Thursday, 01/05/2008 1:56:32 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D206559011
Job Number :	38954		
Estimate Number :	10804		
P.O. Number :		Part Number :	ECN30
This Issue :	01/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	ECN1022
First Issue :	/ /	Project Number :	
Previous Run :	38917	Drawing Revision :	
	Type :	Material :	
	MACHINED PARTS	Due Date :	01/05/2008
Written By :			Qty: 1 Um: Each
Checked & Approved By :			
Comment :			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

UPDATE PAPERWORK:

D206559011

B

32977 (X)

B

34288 8x

B

37535 6x

ADD IIN+ ICA + MDL TO KITS

PER ECN1022

CHANGE LABELS TO NEW CHANGE NUMBER

CHG006

RETURN TO STOCK

8/5/5 SC L5X

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06 J

Job Completion



MUF 08/05/05